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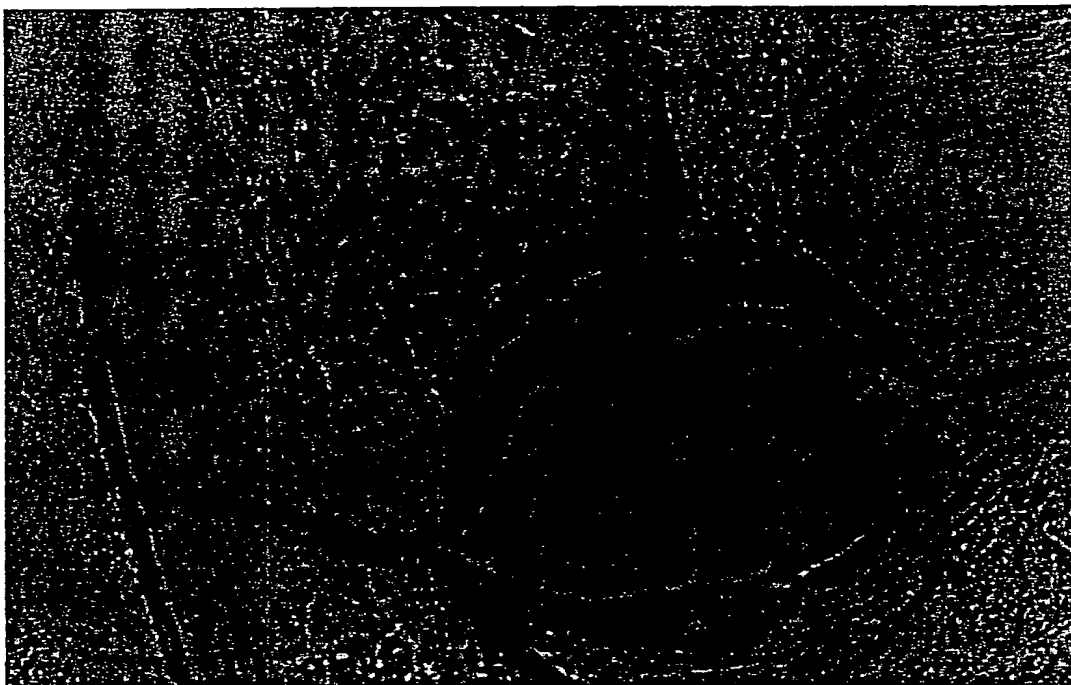
Sample code	4/10/10	4/10/20	4/20/10	4/20/20	6/10/10	6/10/20	6/20/10	6/20/20	8/10/10	8/10/20	8/20/10	8/20/20
average perforation diameter (μm)	400	400	400	400	600	600	600	600	800	800	800	800
approximate spacing between perforations in machine direction (mm)	10	10	20	20	10	10	20	20	10	10	20	20
spacing between perforations in transverse direction (mm)	10	20	10	20	10	20	10	20	10	20	10	20
approximate perforation density (perforations/ m^2) in perforated area	10 000	5 000	5 000	2 500	10 000	5 000	5 000	2 500	10 000	5 000	5 000	2 500
power (%)	3	1	3	1	5	2	5	2	7	3	7	3
puls frequency (kHz)	0.55	0.26	0.55	0.26	0.55	0.26	0.55	0.26	0.55	0.3	0.55	0.3
galvo speed (mm/s)	4000	4000	4000	4000	4000	4000	4000	4000	4000	4000	4000	4000
start positioning	x=4; y=160	x=4; y=160	x=4; y=160	x=4; y=160	x=4; y=160	x=4; y=160	x=4; y=160	x=4; y=160	x=4; y=160	x=4; y=160	x=4; y=160	x=4; y=160
wpa1	x=4; Y=160	x=4; Y=160	x=4; Y=160	x=4; Y=160	x=4; Y=160	x=4; Y=160	x=4; Y=160	x=4; Y=160	x=4; Y=160	x=4; Y=160	x=4; Y=160	x=4; Y=160
gpa1	x=-4; y=160	x=-4; y=160	x=-4; y=160	x=-4; y=160	x=-4; y=160	x=-4; y=160	x=-4; y=160	x=-4; y=160	x=-4; y=160	x=-4; y=160	x=-4; y=160	x=-4; y=160
delay1	1	50	150	150	1	30	120	150	1	1	150	150
wpa2	x=4; y=-160	x=4; y=-160	x=4; y=-160	x=4; y=-160	x=4; y=-160	x=4; y=-160	x=4; y=-160	x=4; y=-160	x=4; y=-160	x=4; y=-160	x=4; y=-160	x=4; y=-160
gpa2	x=-4; y=-160	x=-4; y=-160	x=-4; y=-160	x=-4; y=-160	x=-4; y=-160	x=-4; y=-160	x=-4; y=-160	x=-4; y=-160	x=-4; y=-160	x=-4; y=-160	x=-4; y=-160	x=-4; y=-160
delay2	1	50	150	150	1	30	120	150	1	1	150	150

Figure 1

Sample code	Air pockets after stuffing	Surface craters after cooking	Removal of the net	Additional remarks
Standard	partially palm sized air pockets	essentially all hams show surface craters with diameters of up to 10 cm	o.k.	
8/20/20	15 % of the hams show air pockets with diameters ranging from 1cm to 4 cm	10 % of the hams show surface craters, 6 % require downgrading	o.k.	essentially all hams show pronounced surface nipples
6/10/10	2 % of the hams show small air pockets	essentially no surface craters which would require downgrading	o.k.	minor surface nipples, difficult to detect visually
4/10/10	5 % of the hams show small air pockets	3 % of the hams show surface craters; about 1-2 % require downgrading (border-line cases)	o.k.	practically no surface nipples
2/10/10	15 % of the hams show big air pockets	12 % of the hams show surface craters, 8 % require downgrading	o.k.	no surface nipples

Figure 2

Figure 3



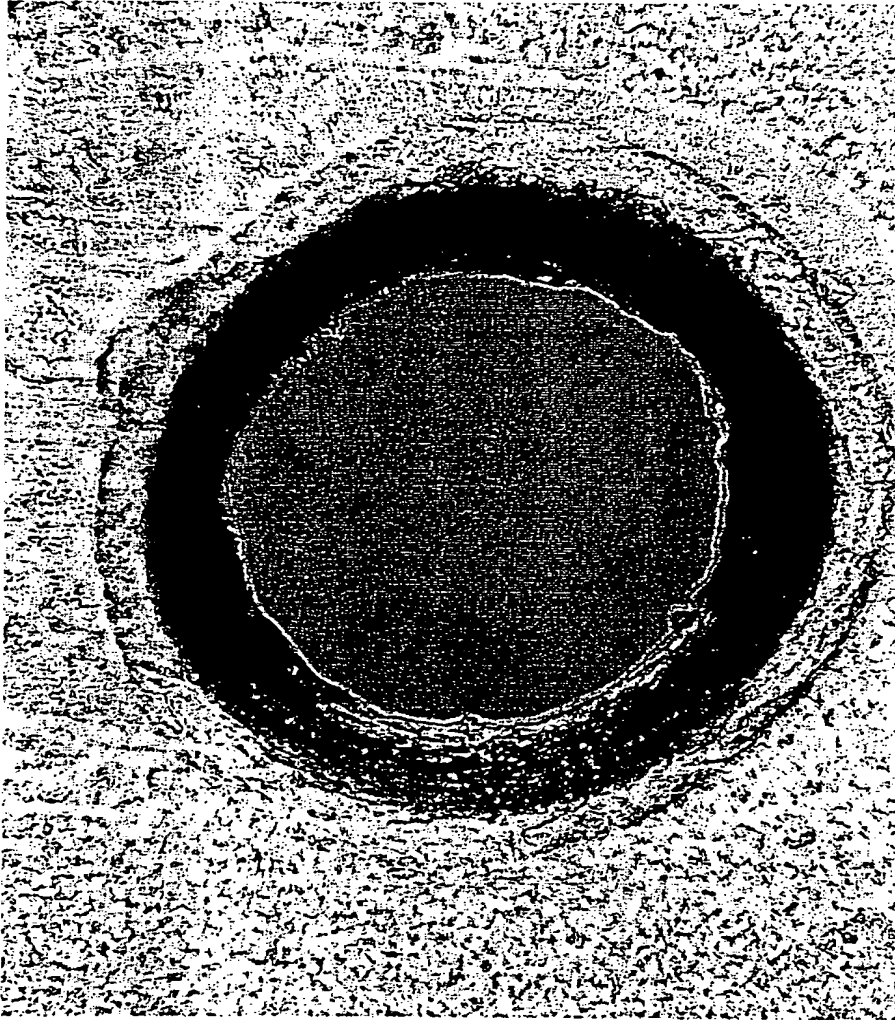


Figure 4

Figure 5

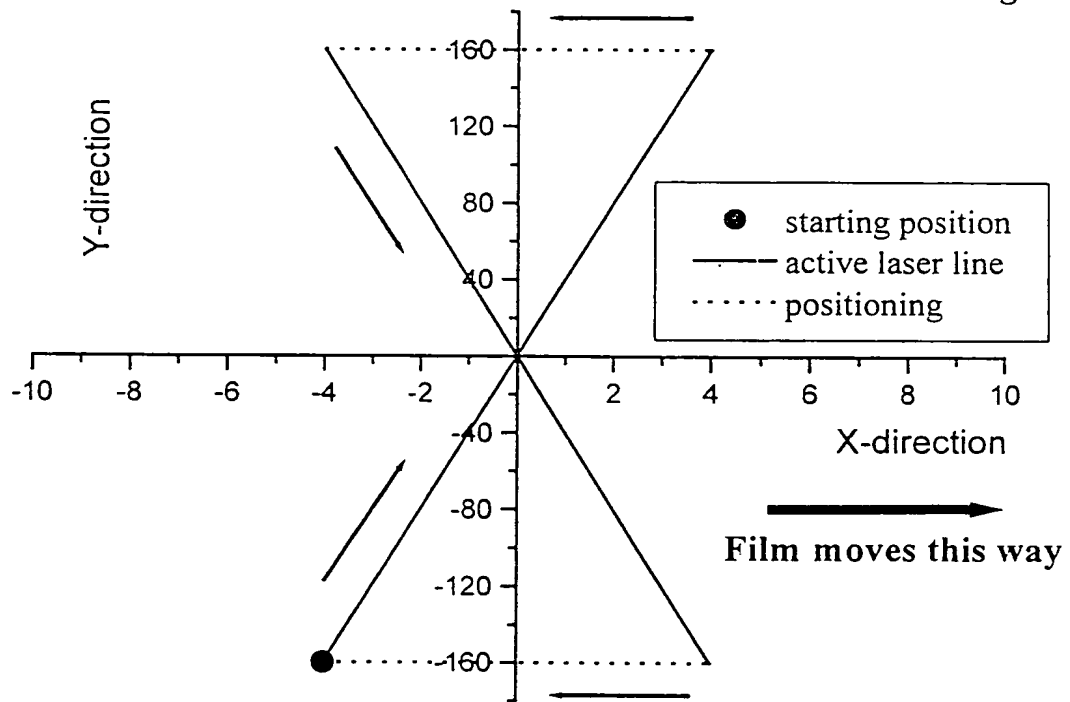


Figure 6

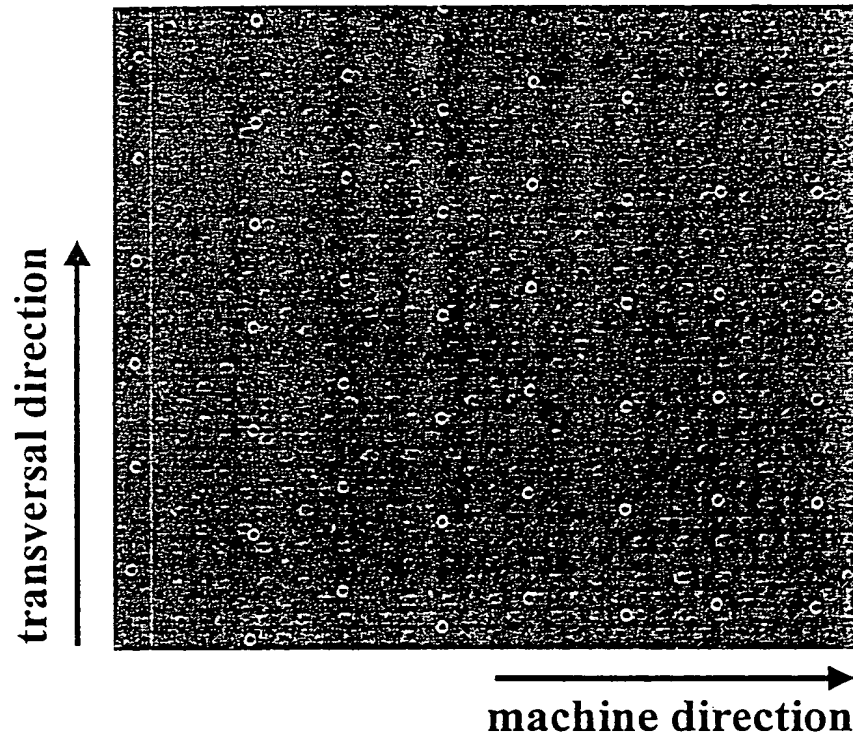


Figure 7

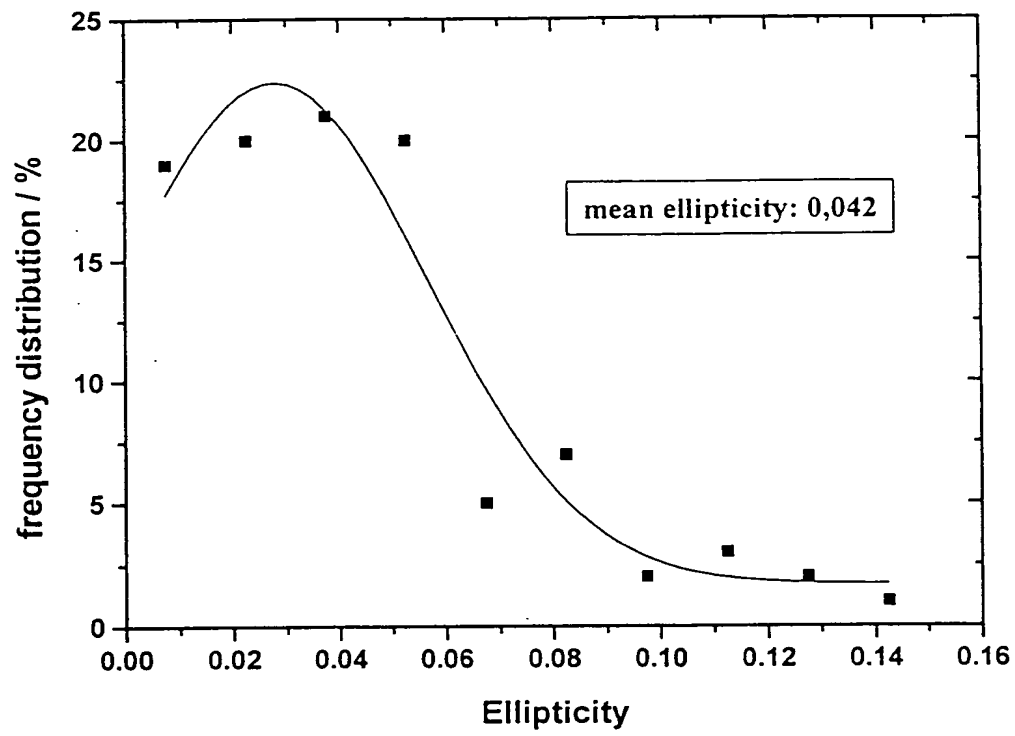


Figure 8

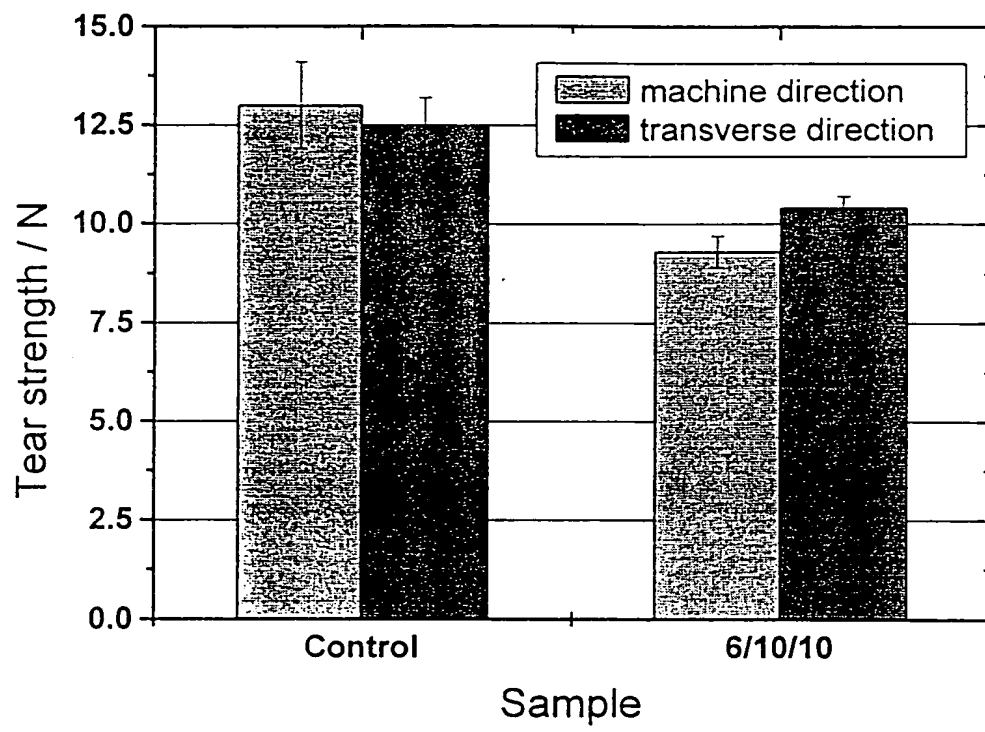


Figure 9

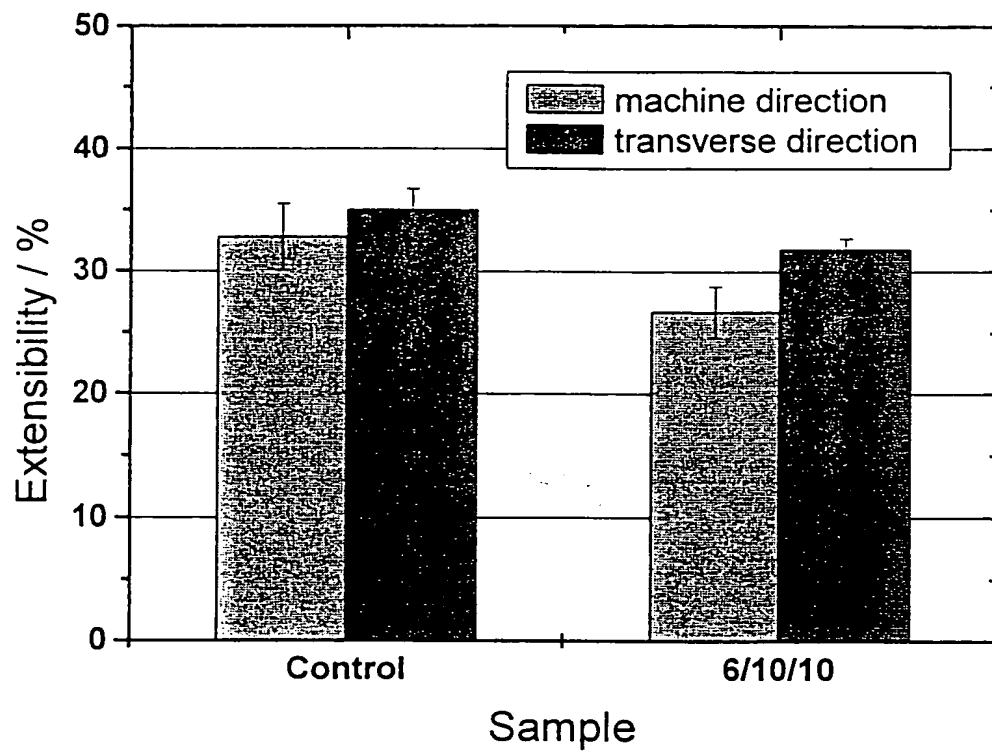
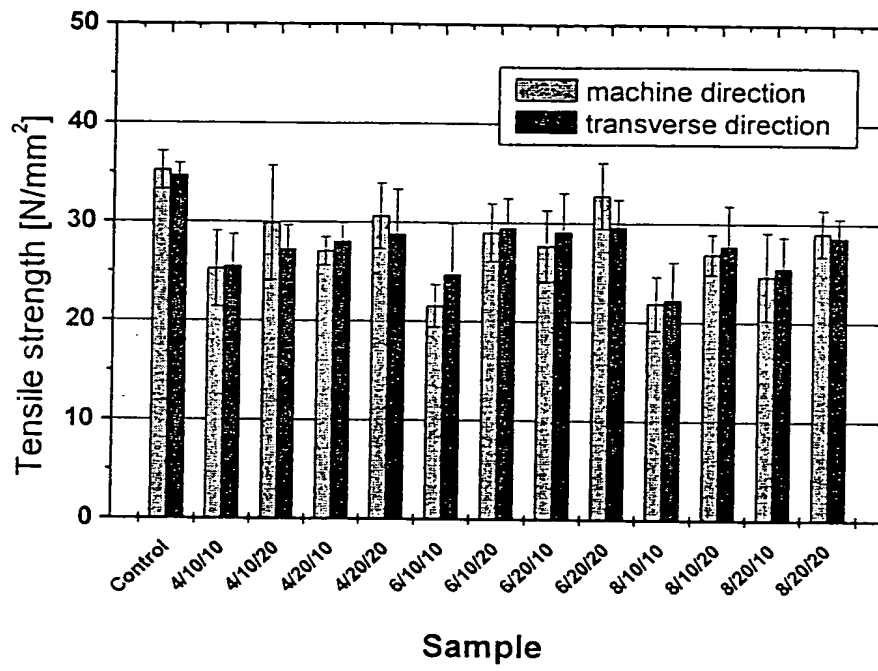


Figure 10



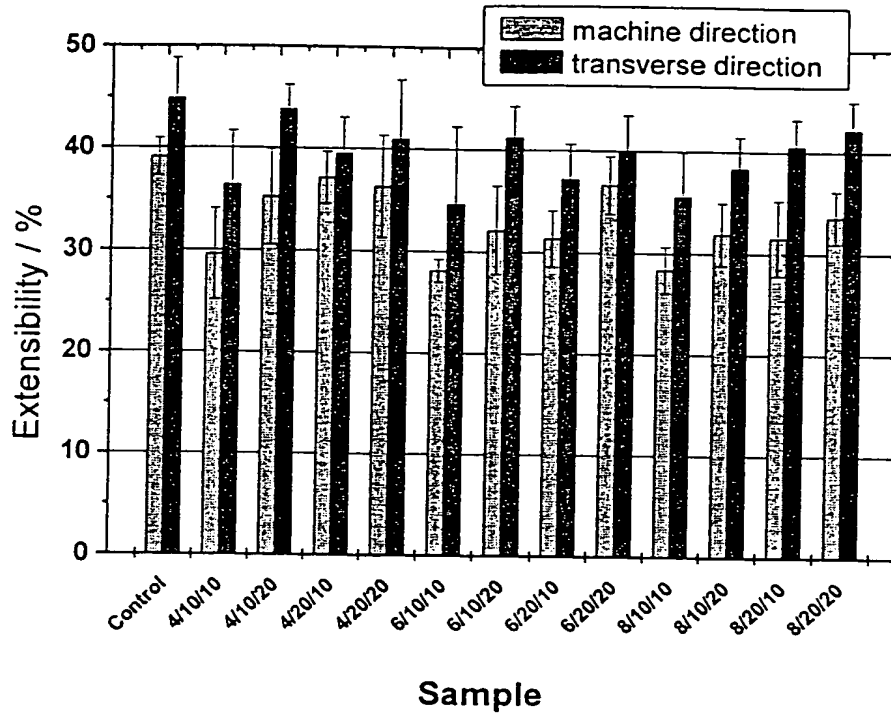


Figure 11

Figure 12

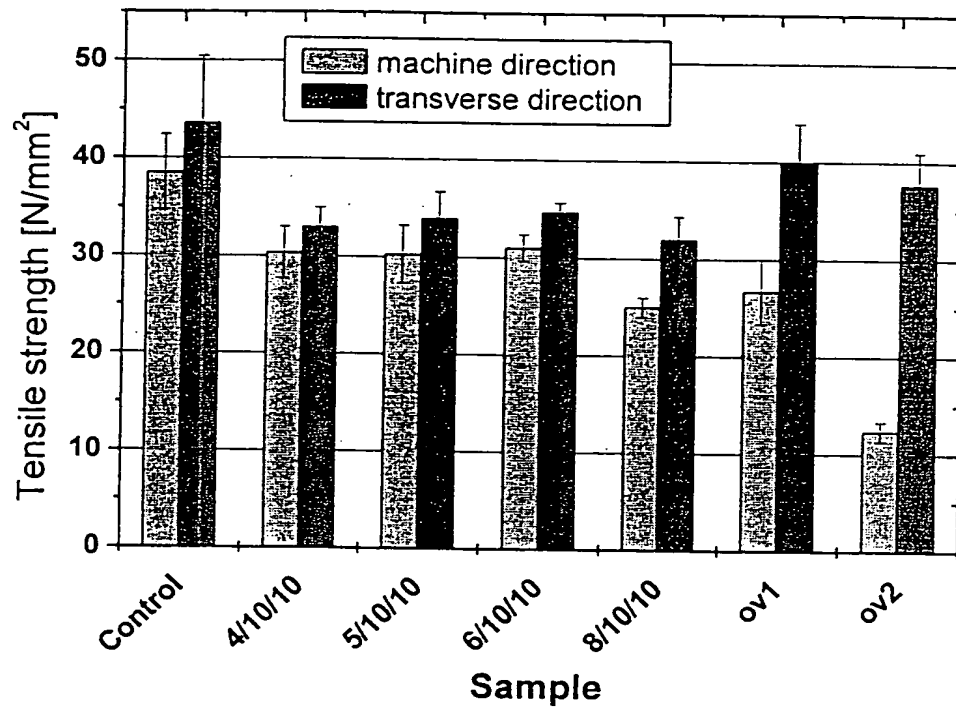


Figure 13

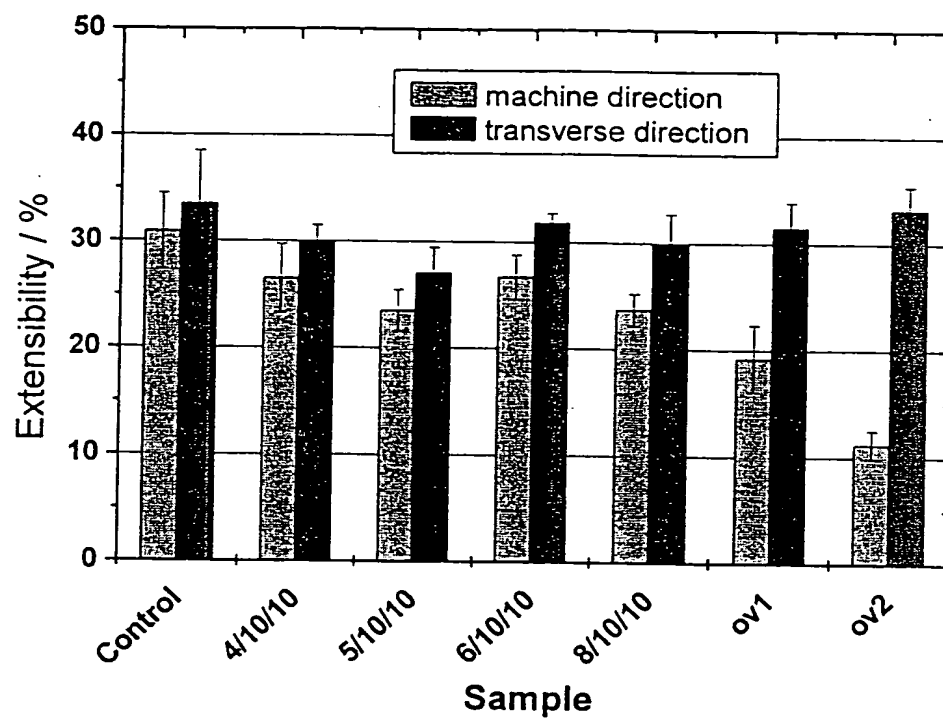


Figure 14

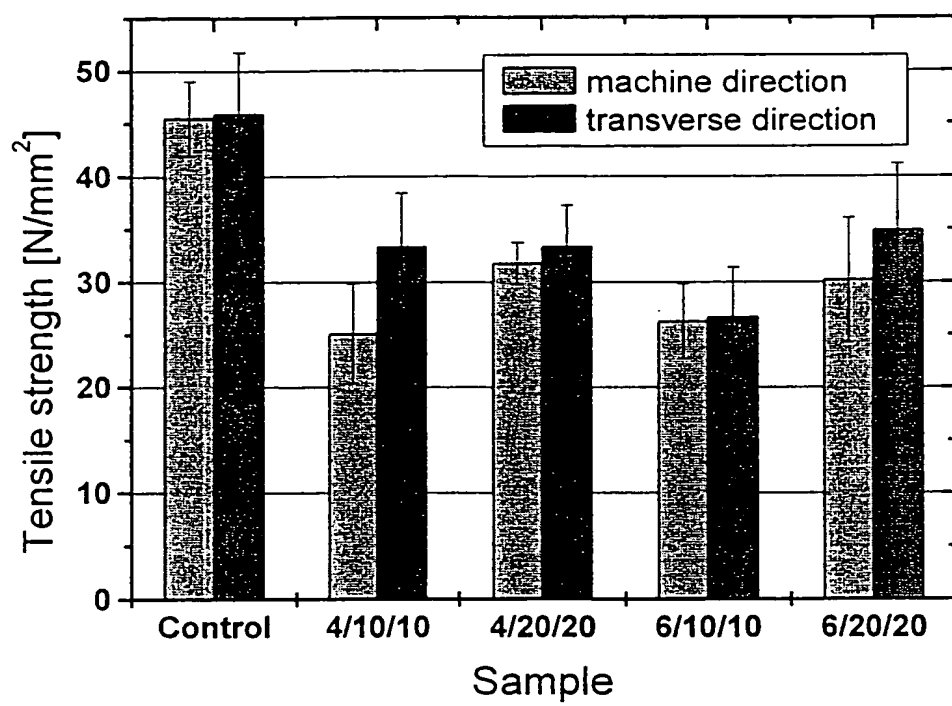


Figure 15

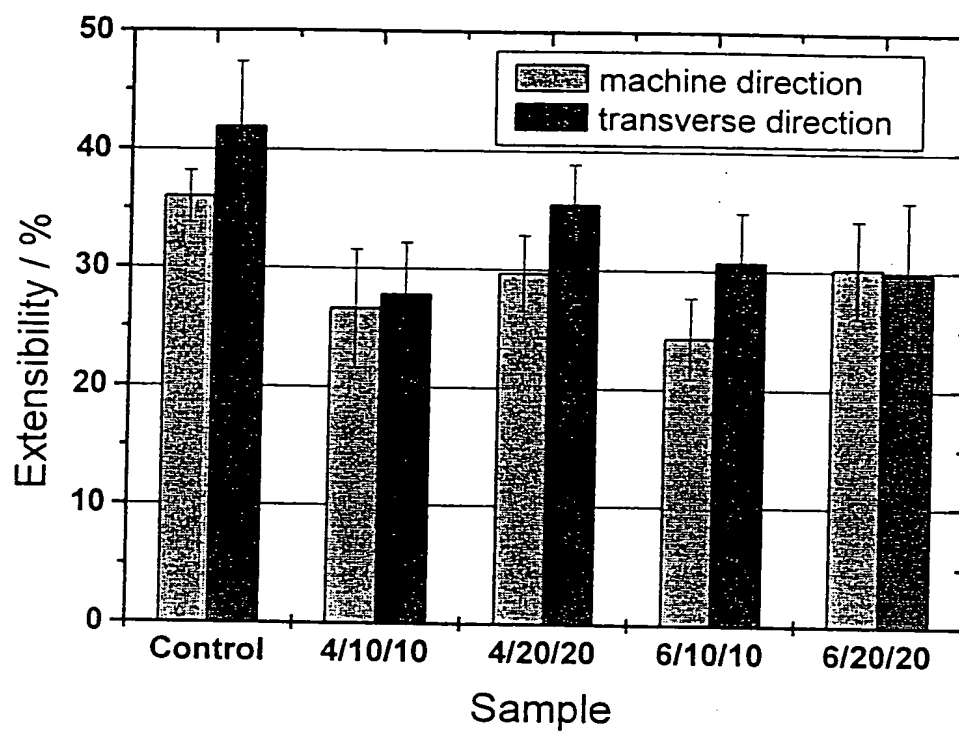


Figure 16

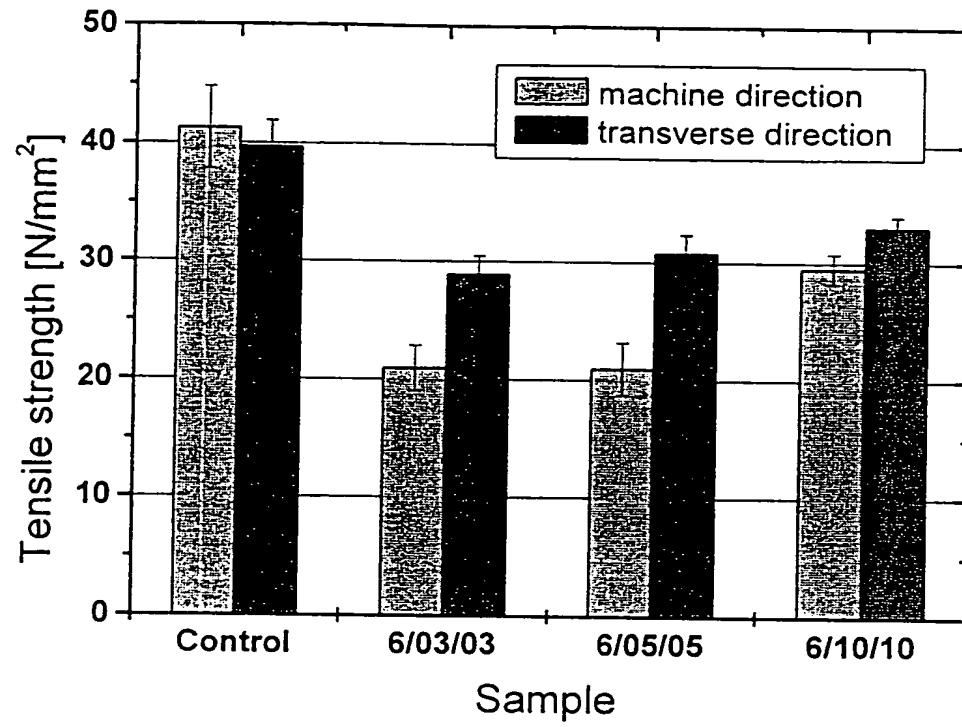


Figure 17

